

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐	Over/Under tolerance ☐																
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Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐	Drawing ☐																
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	Finish ☐																
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐	Misread ☐																
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐																					
Misidentified ☐		Past Due ☐																							

Work Order ID 162741

Monday, June 12, 2017 11:27:54 AM

162741

Page 2

Item ID: SK145-0114-22

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 7/3/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/7/2017 Req'd Qty: 5.00

5

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>S571</u>	0.00							
130									
Packaging	Memo	0.05							
Packaging									
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.50							
Quality Control									

JUN 19 2017

DAS
21
9-89

JUN 19 2017

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
5-30-2018							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Picklist Print

Monday, June 12, 2017 11:28:11 AM

Page 1

Work Order ID: 162741

162741

Parent Item: SK145-0114-22

SK145-0114-22

Parent Item Name: Bushing

Start Date: 7/3/2017

Required Date: 7/7/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 17.06.06 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750		Purchased	No			100	f	5.3451	0.0666	0.350526			

M174R0 750

17-4 round bar .750

**

Location

Loc Qty

Loc Code

MAT

5.3451

m133265

0.0001

m135232

5.345

M174R0.750

m111458

1.0^{pt}

DAS

45

9-89

2017-6-14

JFS
17/06/14

~~*MATL~~ NOT PULLED OUT
[OK]

DQA: _____ Date: _____



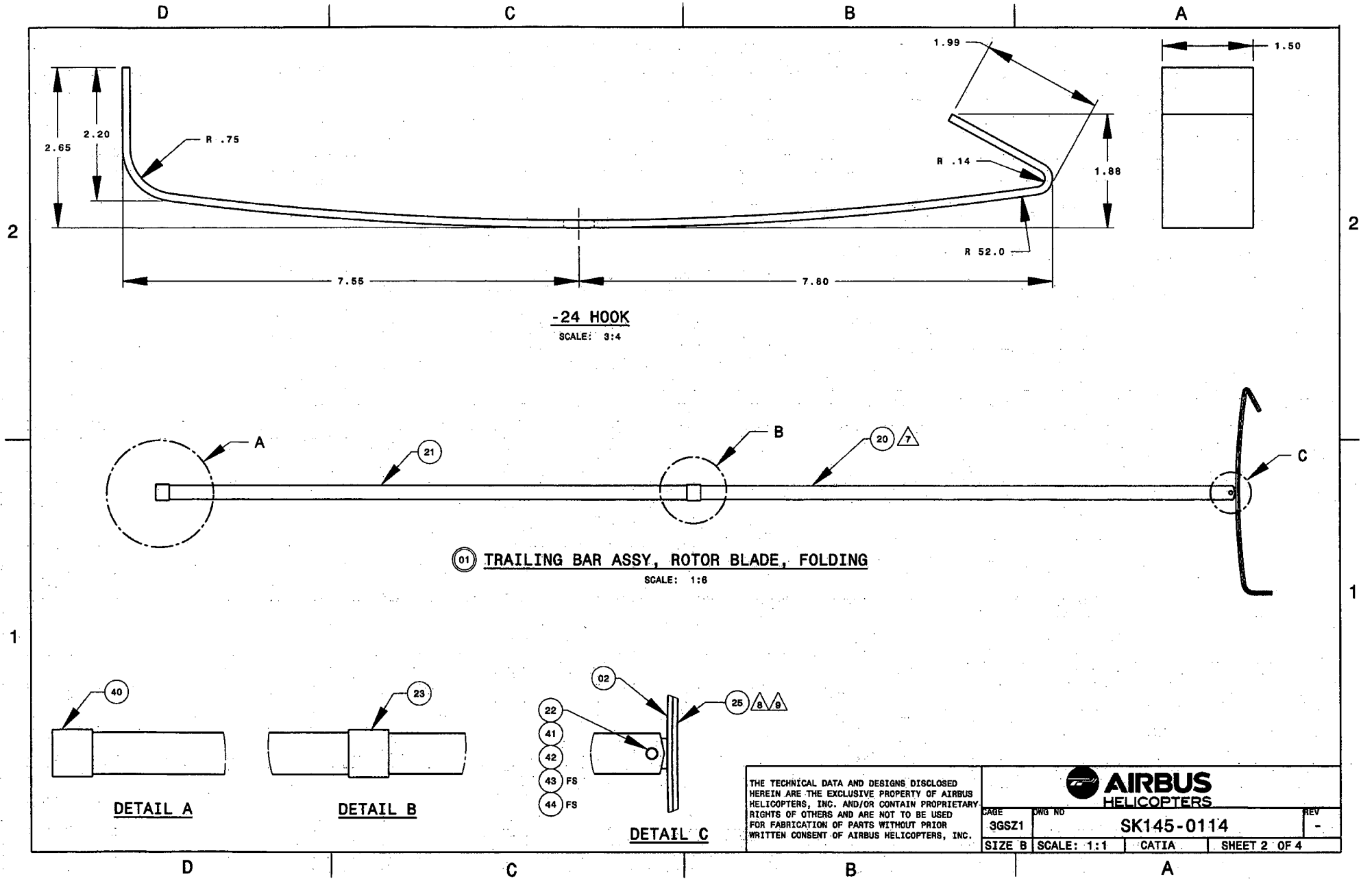
WORK ORDER NON-CONFORMANCE / UPDATE

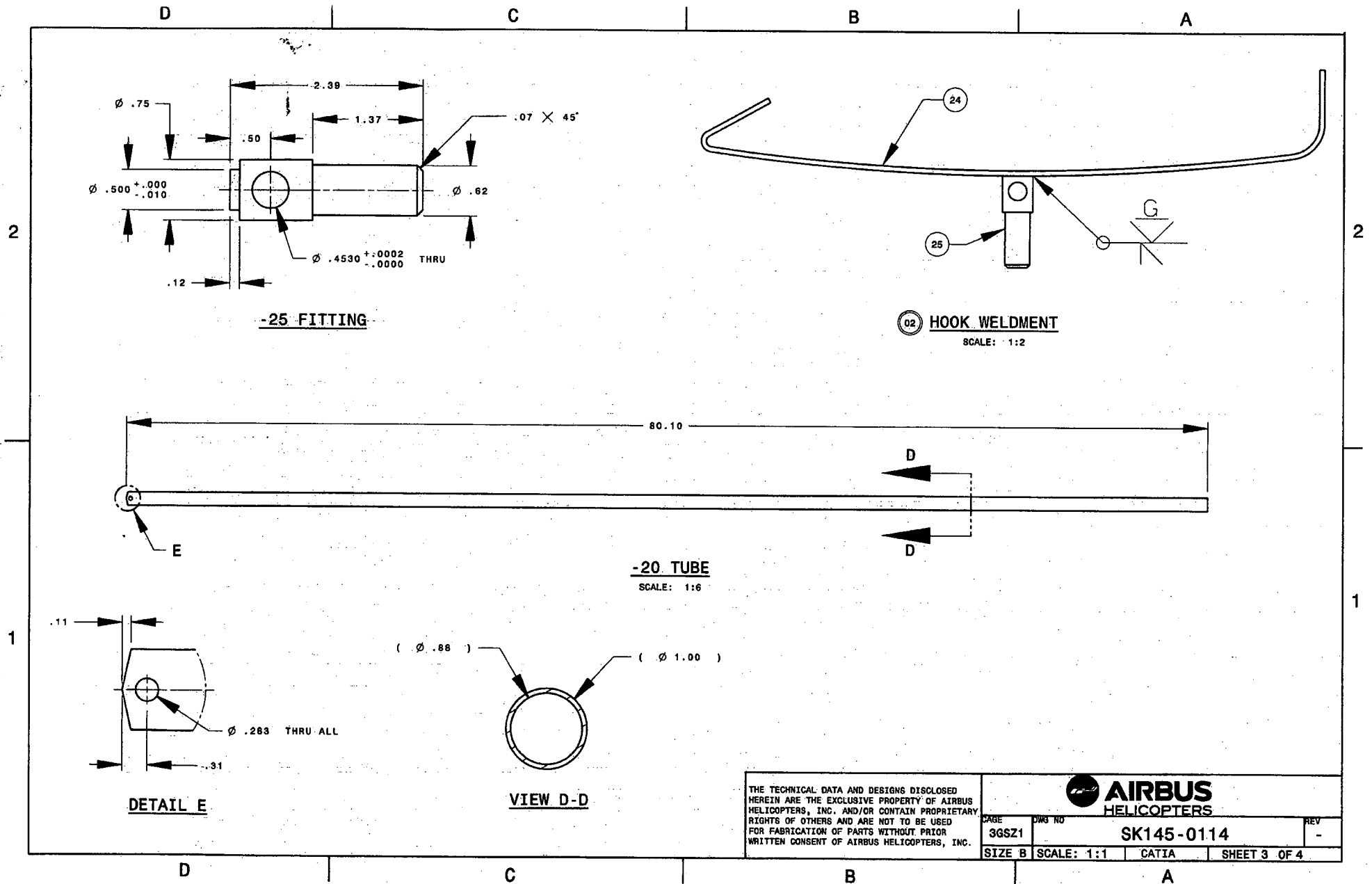
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

1



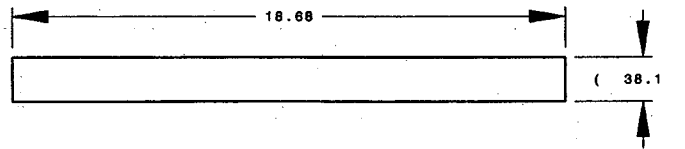


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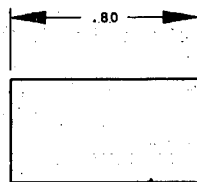
C

B

A

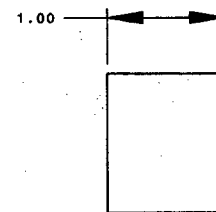
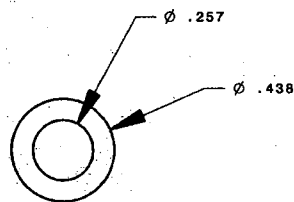


-26 HOOK PAD



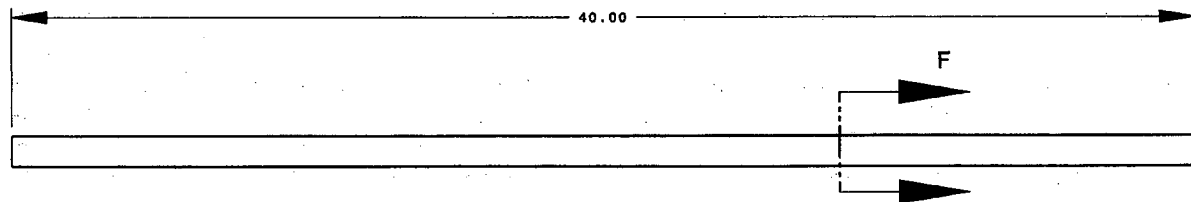
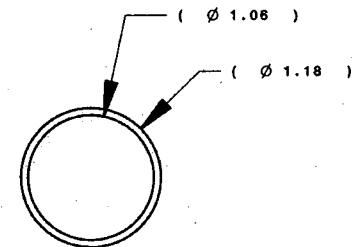
-22 BUSHING

SCALE: 2:1

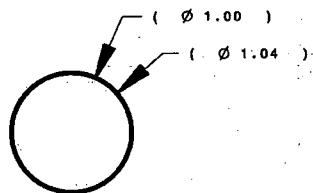


-23 COLLAR

SCALE: 1:1



-21 GRIP



VIEW F-F

SCALE: 1:1

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AIRBUS
HELICOPTERS

CAGE	DWG NO	REV
36SZ1	SK145-0114	-
SIZE B	SCALE: 1:4	CATIA
SHEET 4 OF 4		

D

C

B

A



REFERENCE ONLY

REFERENCE ONLY

*TAPE - No Mast. Black
Vivid Vinyl
DXF. No.*

February 5, 2017

Airbus Helicopters Inc.
2701 N. Forum Drive
Grand Prairie, TX 75052

Attention: Michael Harvey, Strategic Procurement
cc. John Worth, Strategic Procurement

Subject: DART Proposal for EC145 Blade Folding Kit

Dear Michael,

This proposal is being provided per your email request of December 1, 2016, to quote on Airbus Part Numbers for Lakota Blade Folding Kits and the subsequent price reduction negotiation. We are quoting on the following Airbus Helicopter drawings (drawings marked as "UNCONTROLLED COPY/FOR INFORMATION USE ONLY 11/7/2016"):

1. Trailing Bar Assy, Rotor Blade, Folding; P/N SK 145-0014
2. Clamp Assy, Rotor Blade, Folding; P/N SK 145-0015

Furthermore, DART assumptions for the SK145-0114, which have been validated by Airbus, are the following:

1. The material called out on -22 & -25 is AISI 301 SST annealed is sheet or coil material which DART could not find. DART is quoting 17-4 SST as a substitute.
2. We assumed that -21 is vinyl (tape) wrapped around 40" of -20 tube to make a grip.